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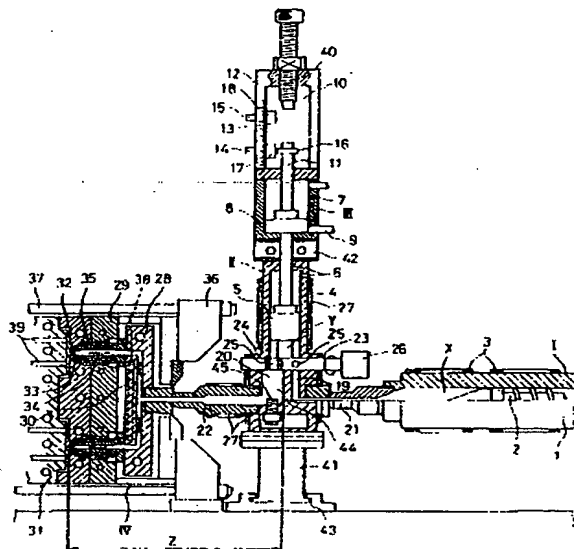
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APPLICANT : SANRI KK;

INVENTOR : TSUTSUMI SHIGERU;

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TITLE : METHOD AND DEVICE FOR
RUNNERLESS INJECTION MOLDING



ABSTRACT : PURPOSE: To injection mold with high accuracy and high precision with minimum force of action by measuring preliminarily accurately the injection volume of molten resin to be injected by an injection mechanism by means of a measuring mechanism and being injected into a cavity of a mold mechanism.

CONSTITUTION: Material resin fed into a cylindrical main body 1 is gradually crushed, softened, melted and stored in a first molten material storage X. The material resin stored therein is transferred smoothly into a second molten material storage Y in a cylindrical measuring cylinder 4 through an end nozzle 21 and an introduction inlet 19. At that time, the accurate injection volume equivalent to the molding volume of a cavity 32 is measured and fed in almost without being compressed, but allowed to be expanded only. The molten resin in the measuring cylinder 4 is fed from an introduction outlet 20 and stored in a third molten material storage Z of a mold mechanism IV through a nozzle section 22. At that time, the plasticized resin in the molten material storage X is transferred to the molten material storage Y at high speed through a feeding inlet 19. Then, the measured molten resin in the molten material storage Z is filled in a cavity 32, rapidly cooled, solidified and released as a molded product.

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